



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEM642V4001102-7

Job Sheet 173765



Part No: RBEM642V4001102-7

Job Qty: 4 ea

Part Name: Block



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/7/18

Job Tracking No:

Due Date: 3/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEM642V4001102 REV 2 IPP REV A 18.03.05 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		3/29/18	0.00	0.00	Start Up Waterjet2		J.C.L.
100	Waterjet	4 pcs		3/29/18	0.00	0.50	Waterjet 2 OMAX		
110	QC	4 pcs		3/29/18	0.00	0.00	QC2 Waterjet 4		
120	CNC Vertical Machining	4 pcs		3/30/18	1.50	0.80	MORI NV5000-1		J.C.L.
130	QC	4 pcs		3/30/18	0.00	0.00	QC2 Machining-5		J.C.L. 18-05-02
140	QC	4 pcs		3/30/18	0.00	0.00	QC8 Machining-5		7/18/05/08
150	Outsource	4 pcs		3/30/18	0.00	0.00	Outsource4		CTG-8
160	Packaging	4 pcs		3/30/18	0.00	0.00	Packaging2		ATK 18/05/11
170	QC	4 pcs		3/30/18	0.00	0.00	QC6		38
180	Packaging	4 pcs		3/30/18	0.00	0.00	Packaging3-2		18-05-11
190	QC21-SA	4 Ea		3/30/18	0.00	0.00	QC21		18/05/11

Part Op 100 - 1-Cut as per Dwg Dwg Rev: 2 Prog Rev: 2- Deburr if necessary

Descriptions: 120 - 1-Machine as per folio FB 972 FOLIO REV: DWG REV: 2-Deburr

150 - Issue P/O to ATC 029831 - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required

160 - Receive

180 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X02.000	6061T6 Bar 1.250 X 2.000	.8360 ft (.209 ea)	90-Start up Operation	5043 713 0.833'

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
	T6B1.250X02.000	1	24	0

Part Specifications

Specifications could not be found.



Container No: S067772



Part: RBEM642V4001102-7

Job No: 173765

Serial No/Batch: S067772

Revision: 2

Inspector:

Date: 05/02/18

Plex 3/7/18 7:42 AM Dart.lajeunesse.marie

PQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

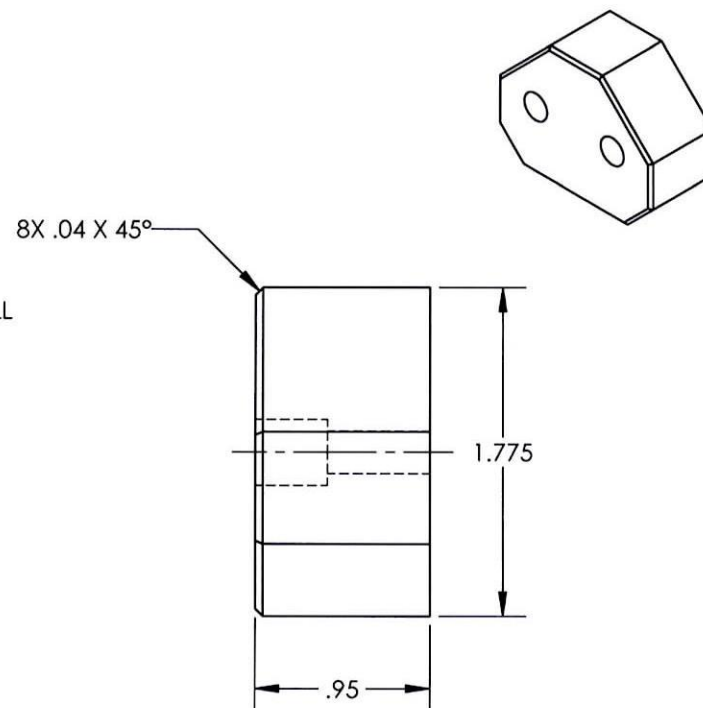
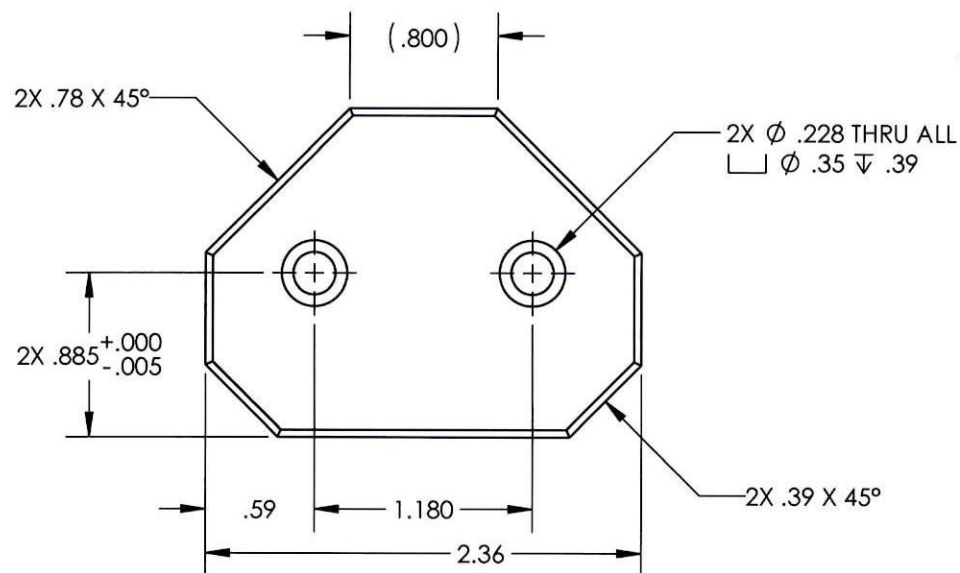
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1737652

20180427

(-7)

BLOCK

DART AEROSPACE	
TITLE TRH DAMPER SETTING TOOL	
DWG NO. RBEM642V4001102-7	REV 2
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH CLEAR ANODIZE	.XX ± .01 ANGLES ± 5°
SPEC MIL-A-8625F, TYPE II, CLASS I	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 4/11/2016 SHEET 5 OF 11

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039831**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039831
PO Date: 5/8/18
Due Date: 5/10/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	176630	RBT400315-7	Bolt -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	5/10/18	10 pcs	0 pcs ✓ 10x	10 pcs	\$6.666666/pcs A19/05/11	\$66.67
Line Item Note *asap*										
2	173761	RBEM642V4001102-1	Base Plate -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	5/10/18	4 pcs	0 pcs	4 pcs	\$7.50/pcs	\$30.00

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	173764	RBEM642V4001102-5	Post 2 -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	5/10/18	4 pcs	0 pcs	4 pcs	\$7.50/pcs	\$30.00
							4x		md. 18/05/11	
4	173763	RBEM642V4001102-3	Post -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	5/10/18	4 pcs	0 pcs	4 pcs	\$7.50/pcs	\$30.00
							4x		md. 18/05/11	
5	176430	RBEM631V3027101-1	Threaded Half -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	5/10/18	6 pcs	0 pcs	6 pcs	\$8.00/pcs	\$48.00
							6x		AT 19/05/11	
6	176431	RBEM631V3027101-3	Counterbore Half -Issue P/O to Groupe Altech: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	5/10/18	5 pcs	0 pcs	5 pcs	\$8.00/pcs	\$40.00
							5x		AT 18/05/11	
7	173765	RBEM642V4001102-7	Block -Issue P/O to Group Altech: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	5/10/18	4 pcs	0 pcs	4 pcs	\$8.00/pcs	\$32.00
							4x		AT 18/05/11	

1A5
38
989

CL



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

009132- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
11-May-2018		Curtis Anderson		39831				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	RBT400315-7 Rev.	RBT400315-7 01 -BLACK OXIDE ON SST MIL-DTL-13924C BLACK OXIDE FINISH MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	10	10	0	0	0
2	RBEM642V4001102-1 Rev.	RBEM642V4001102-1 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS ZINC PLATE ASTM B633 TYPE 1 SC2	ZINC CH	4	4	0	0	0
5	RBEM631V3027101-1 Rev.	RBEM631V3027101-1 01 -ANO-CLEAR [ANODIZE CLEAR] CLEAR ANODIZE PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT.	ANODIZE CH	6	6	0	0	0
6	RBEM631V3027101-3 Rev.	RBEM631V3027101-3 01 -ANO-CLEAR [ANODIZE CLEAR] CLEAR ANODIZE PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT.	ANODIZE CH	5	5	0	0	0
7	RBEM642V4001102-7 Rev.	RBEM642V4001102-7 01 -ANO-CLEAR [ANODIZE CLEAR] CLEAR ANODIZE PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT.	ANODIZE CH	4	4	0	0	0
8	RBT400313-9 Rev.	RBT400313-9 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	8	8	0	0	0
9	RBT18547-1 Rev.	RBT18547-1 01 -ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	10	10	0	0	0
10	269T9310-3 Rev.	269T9310-3 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE ZINC PLATE ASTM B633 TYPE 2 SC2	ZINC CH	5	5	0	0	0

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